

# Work Order ID 101178

\*101178\*

Page 1

May-02-13 11:51:17 AM

Item ID: D205-634-111 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube  
 Start Date: 5/02/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/02/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: rework - ECN13-544

Approvals: Process Plan: W Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D205-634	G

100  
 \*100\*  
 DC  
 Document Control

0.00

Memo  
 Photocopy bluefile & type labels per PPP D205-634-111  
 CHG 004

101  
 \*101\*  
 HandFinish  
 Hand Finishing

0.00

Memo  
 1 X D205-634-111 B82859  
 REMOVE THE 2 WEARPLATES  
 1 X D4406-041 / 1 X D4406-043  
 SCRAP  
 INSTALL NEW WEARPLATES AT REV.C  
 1 X D4406-041 B 98746  
 1 X D4406-043 B 98747

DAS		170 ABERDEEN ST HAYKESBURY ON CANADA N0A 1K7 TEL: 1-800-888-3442 www.das-aerospace.com	
PATENT			
P/N	D205-634-111	CHG	CHG003
DESC	Skidtube	STC	SH96-88
LOT	B82859	STC	SR00563NY
MODEL	Bell 205/210/212/214/412/UH-1H		
10 APPROVAL 4-18-88		MADE IN CANADA	
		02729-4	

for mus 13-5-17  
 1 x 1 13/05/15

101178

**Work Order ID 101178****\*101178\***

Page 2

May-02-13 11:51:17 AM

Item ID: D205-634-111

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube

Start Date: 5/02/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/02/13 Req'd Qty: 1.00

**\*1\***

Customer:



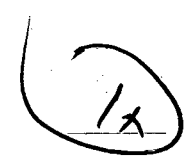
Reference: rework - ECN13-544

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 <b>*105*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00 13515				1			
110 <b>*110*</b> Packaging Packaging	Pick Kit  Memo ENSURE ORIGINAL KIT IS IN BOX	0.00  0.00				1	8	13-5-23	
120 <b>*120*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00		13/5/23					

**Work Order ID 101178****\*101178\***

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May-02-13 11:51:17 AM

Item ID: D205-634-111

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube

Start Date: 5/02/13 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/02/13 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: rework - ECN13-544

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	REPACKAGE PER PPP UISNG NEW B/N NEW LABELS AND PAPERWORK REQ'D @ CHG004 Identify and pack for shipping as per PPP D205-634-111 Location: <u>073</u> PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
06  
9-89

1 8 13-5-23

13/5/27

MCS 13-05-23

# Picklist Print

May-02-13 11:51:17 AM

Work Order ID: 101178  
Parent Item: D205-634-111  
Parent Item Name: Skidtube

Start Date: 5/02/13  
Start Qty: 1.00  
Required Date: 5/02/13  
Required Qty: 1.00

Comments: IPP revA 11.09.26 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER  
ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-634-111 Skidtube		Manufactured	No				Each	0.0000		1	82859h		
D4406-041 Fwd Wearplate Assembly		Manufactured	No				Each	6.0000		1	13/05/15		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		6							
				98746		6			x1				
D4406-043 Aft Wearplate Assembly		Manufactured	No				Each	6.0000		1	13/05/15		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		6							
				98747		6			x1				

# ENGINEERING CHANGE NOTICE

## DART AEROSPACE LTD

Date: 13.03.21	Job No.: ENG4108	ADR Yes/No: Y	ADR Date: 13.03.21	ECN #: 13- 544
Product No.: D205-634	Created By: AJS	Approved By: [Signature]		
Product Name: SKID TUBE (TRAINING WEARPLATE)	Checked By: [Signature]			

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	NF	
Production Manager / Coord.	Y	LL/MF	
Purchasing Coord.	N	CL	
Production Engineering Coord.	Y	DD/JLM	
Production Engineering Coord.		DL	
Customer Order Processing		RM/CA	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS	
QC Coordinator	Y	ED	
Customer Support	Y	SW/LM	
Customer Technical Support	Y	MB/DS	
Marketing		HM	

Reason for Change: DESIGN IMPROVEMENT

Documents Affected:  
D4406 & D4407 REV. C  
MDL-D205-634 REV. Y

PAPERWORK UPDATE ☐

PARTS MUST COMPLY ☒

PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	AJS		13.03.21 DS
6	Update Product Compatibility Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		13.03.21 [Signature]
11	Update Product Specification Files	N			
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		13.03.21 [Signature]
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Create/Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	Y	KJ	SEE BELOW	13.03.21 [Signature]
19	Create / Update PPP's	Y	KJ		
20	Red Decals required?	Y	KJ		
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		13.03.21 [Signature]
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		13.03.21 [Signature]
24	Manufacturing Licensing Agreement Update	N			

**Description / Action:**

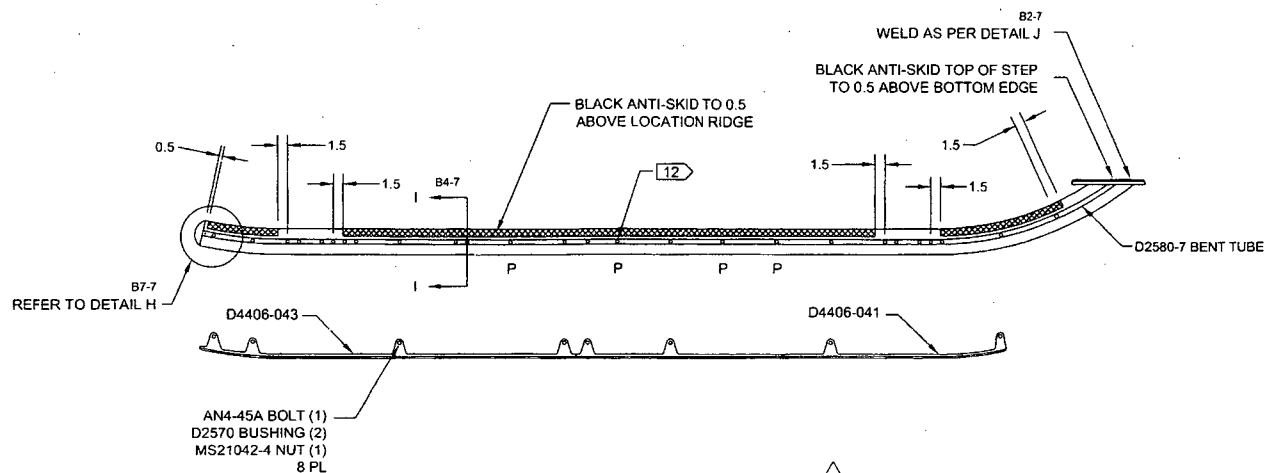
ROLL D205-634-111 TO CHG 004  
ROLL D205-634-141 TO CHG 004  
ROLL D205-634-143 TO CHG 003

Scrap any D4406 or D4407 parts in stock manufactured before Rev. C

Release D4406 & D4407

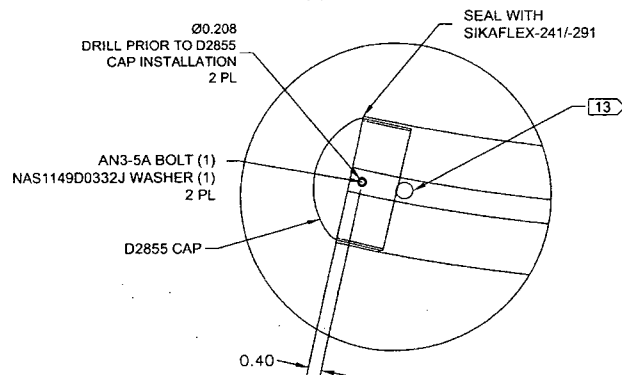
ECN Verified & Complete: \_\_\_\_\_

Date: \_\_\_\_\_

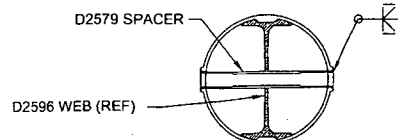


D2580-047 ASSEMBLY DETAIL E

DETAIL H C6-7  
SCALE 5X



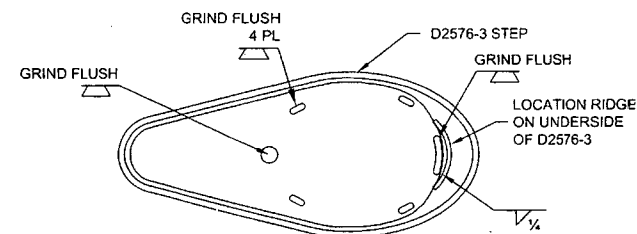
SECTION I-I D5-7  
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (25 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL J D3-7  
SCALE 5X



DEO ATTACHED  
**RELEASED**  
2011-08-29

DESIGN	4	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 6 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT BEING FORWARDED FROM DART AEROSPACE LTD.</small>	